

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025310**Date Inspected:** 03-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Corporation, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Mai Quin Li**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Bike Path Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Delbert Humphrey was present during the times noted above for observations relative to the work being performed at ZPMC.

OBG Bay # 16

WELDING

This QA Inspector observed the following work in progress:

FCAW welding of weld identified as BKSA10-020, located on Cantilever Truss Assembly BK21A. Welder is identified as 201074. ZPMC Quality Control (QC) is identified as Mr. Mai Quin Li. The welding variables recorded by QC appeared to comply with WPS-FCAW-1F-ESAB.

FCAW welding of weld identified as BKSA9A-012, located on Cantilever Truss Assembly BK21A. Welder is identified as 201074. ZPMC Quality Control (QC) is identified as Mr. Mai Quin Li. The welding variables recorded by QC appeared to comply with WPS-FCAW-1F-ESAB.

OBG Bay # 13

WELDING

This QA observed the following components in this bay, OBG, Steel Barriers.

Threads were being drilled in holes on backside of steel barrier E2-SB33-001.

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OBG Bay # 14

WELDING

This QA observed the following components in this bay, OBG, Steel Barriers.

Slotted holes being drilled in flange on Traveler Rail TR3021TR2.

OBG Bay # 28

WELDING

This QA observed the following components in this bay, OBG, Mock-Up Service Hand Rails. This QA observed no work being performed on the above mentioned components during the time QA was present.

Bay #19

NDT

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 09635.

This QA inspector performed Magnet Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. Time of inspection was 14:15 hours. The members are identified as follows OBG Component. The weld designations reviewed are as follow:

BKSA019-001-002, 003, 014, 015, 010, 012, 001, 013, 006, 017, 005, 007

Bay #19

NDT

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 09663.

This QA inspector performed Magnet Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. Time of inspection was 0835 hours. The members are identified as follows OBG Component. The weld designations reviewed are as follow:

BK24A11-001-002,007, 008, 017, 023, 029, 030, 039

BK24A10-001, 021, 023, 069, 070, 008, 012, 066, 067

Bay #19

NDT

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 09633.

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an UT report for this date. Time of inspection was 15:00 hours. The members are identified as follows OBG Component. The weld designations reviewed are as follow: BKSA019-001-004, 008, 016, 018.

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Bay #16

NDT

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 09631.

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an UT report for this date. Time of inspection was 16:50 hours. The members are identified as follows OBG Component. The weld designations reviewed are as follow: BKSA10C-001-002,003.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Humphrey, Delbert

Quality Assurance Inspector

Reviewed By: Hall, Steven

QA Reviewer